

Work Order ID 147909

Friday, June 17, 2016 7:55:37 AM

Page 1

Item ID: D3401-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tow Cap Assembly

Start Date: 6/9/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/21/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: JUN 17 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3401

Rev B

100

0.00

100

Bandsaw

BAND SAW

Jeaspa Bandsaw

Memo

Cut Blanks 4.20" Long

0.00

14

0

DAS

45

9-89

2016-07-05

110

0.00

110

Doosan

DOOSAN LATHE

Doosan Lathe

Memo

Turn as per Folio FA532 & Dwg D3401

Folio Rev: AA

Dwg Rev: B

Deburr

0.00

14

0

DAS

45

9-89

2016-07-05

120

0.00

120

QC

QC2- Inspect parts off machine FAI/FAIB

Quality Control

Memo

0.00

14

0

DAS

45

9-89

2016-07-05

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N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

Start Date: 6/9/2016 **Start Qty:** 12.00

12

Customer:

Required Date: 6/21/2016 **Req'd Qty:** 12.00

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

150

Small Fab

0.00

Small Fab

Memo

DAS
30
9-89

14

SEP 06 2015

Small Fab

Drill and c'sink using DT8782 as per Dwg D3401

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

DAS
18
9-69

16/09/02

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

2016/09/12
BET

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147909

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Item ID: D3401-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tow Cap Assembly
Start Date: 6/9/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 6/21/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00							
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
195 *195* HandFinish Hand Finishing	Assemble as per dwg Memo	0.00 0.00							

ALL A - see w/o 149749 to continue DG - Amed

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Item ID: D3401-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tow Cap Assembly
Start Date: 6/9/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 6/21/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : FP001	0.00 0.00							
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Qty 10 pulled onto 149749

SA SEP 12 2016

Picklist Print

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Page 1

Work Order ID: 147909

147909

Parent Item: D3401-041

D3401-041

Parent Item Name: Tow Cap Assembly

Start Date: 6/9/2016

Required Date: 6/21/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A05.09.01New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R3.500

Purchased

No

200

f

11.2840

0.35

~~4421053~~

4.90

M6061T6R3 500

6061 RD bar 3.50

Location

Loc Qty

Loc Code

MAT013

11.284

m132876

11.284

NAS1330C3KB116

Purchased

No

100

Each

44.0000

4

~~5.15~~

56

DAS

45

9-89

2016-07-05

NAS1330C3KB116

Rivnut

Location

Loc Qty

Loc Code

FP001

44

103337

2

M129913

4

M132825

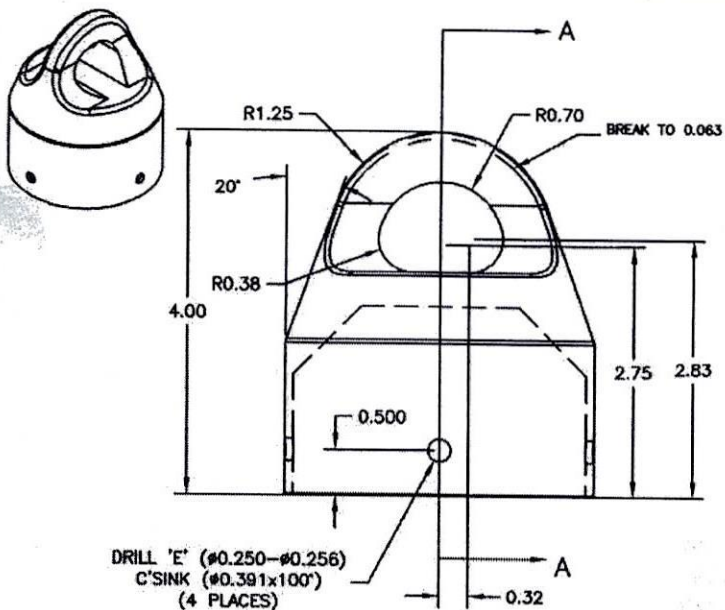
9

M134509

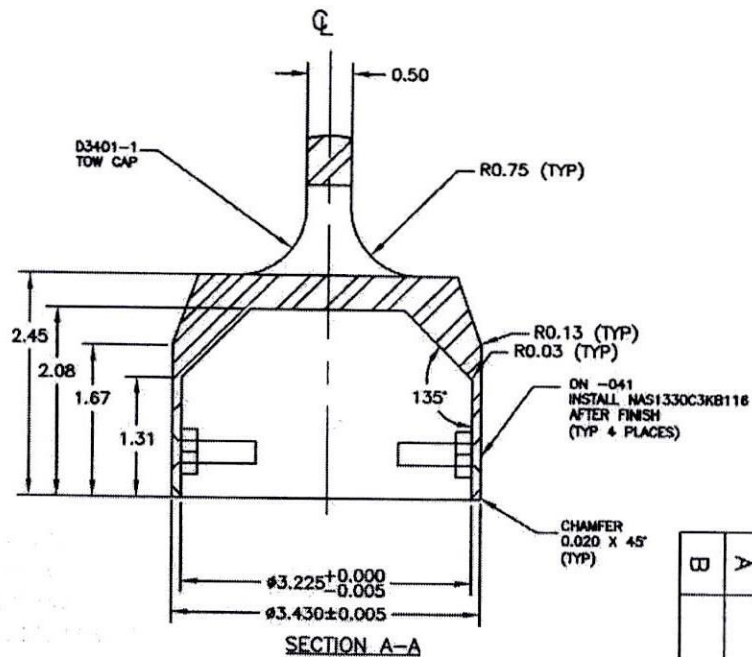
29

NA
See
40
149749

DART



D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-200/8
(REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

05-08-07

DESIGN		UNKNOWN		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
PH	PH	DRAWING NO.		REV. B	
CHECKED	APPROVED	D3401		SHEET 1 OF 1	
DATE		TITLE		SCALE	
05.06.09		TOW CAP		1:2	
A		NEW ISSUE			
B		05.02.24			
		05.06.09		CHAMFER INSIDE, REMOVE RADIUS	

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